

# Work Order ID 82125

**\*82125\***

Page 1

March-23-12 10:45:15 AM

Item ID: D3283-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 23/03/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 06/04/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals: Process Plan: HL3

Date: 12/03/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3283

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

24

0

Jm/SL  
12-4-28

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

24

0

Jm/SL  
12-4-28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82125

March-23-12 10:45:15 AM

**\*82125\***

Page 2

Item ID: D3283-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 23/03/2012 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 06/04/2012 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		Sc 76430		(cat) 24			
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				(24)		76430	
160 <b>*160*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				24X			M/L 12/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 82125

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Page 3

March-23-12 10:45:15 AM

Item ID: D3283-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Doubler

Stop **\*NS2\***

Start Date: 23/03/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 06/04/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: 176

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12/17/30 (24)

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/14/30 MLF  
12-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-23-12 10:45:19 AM

Page 1

Work Order ID: 82125

\*82125\*

Parent Item: D3283-1

\*D3283-1\*

Parent Item Name: Doubler

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 24.00

Required Qty: 24.00

## Comments:

IPP A04.09.28New issueKJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased			No	100	sf	412.9996	0.2361	5.964632			

\*M6061T6S 063\*

\*\*

6061-T6 .063 Sheet

## Location

## Loc Qty

## Loc Code

MAT021

412.9995684

113608

0

116308

6.51556842

117285

70.544

119331

48

119802

20.94

120218

28

120866

239

120866

6

5m/17  
12-4-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

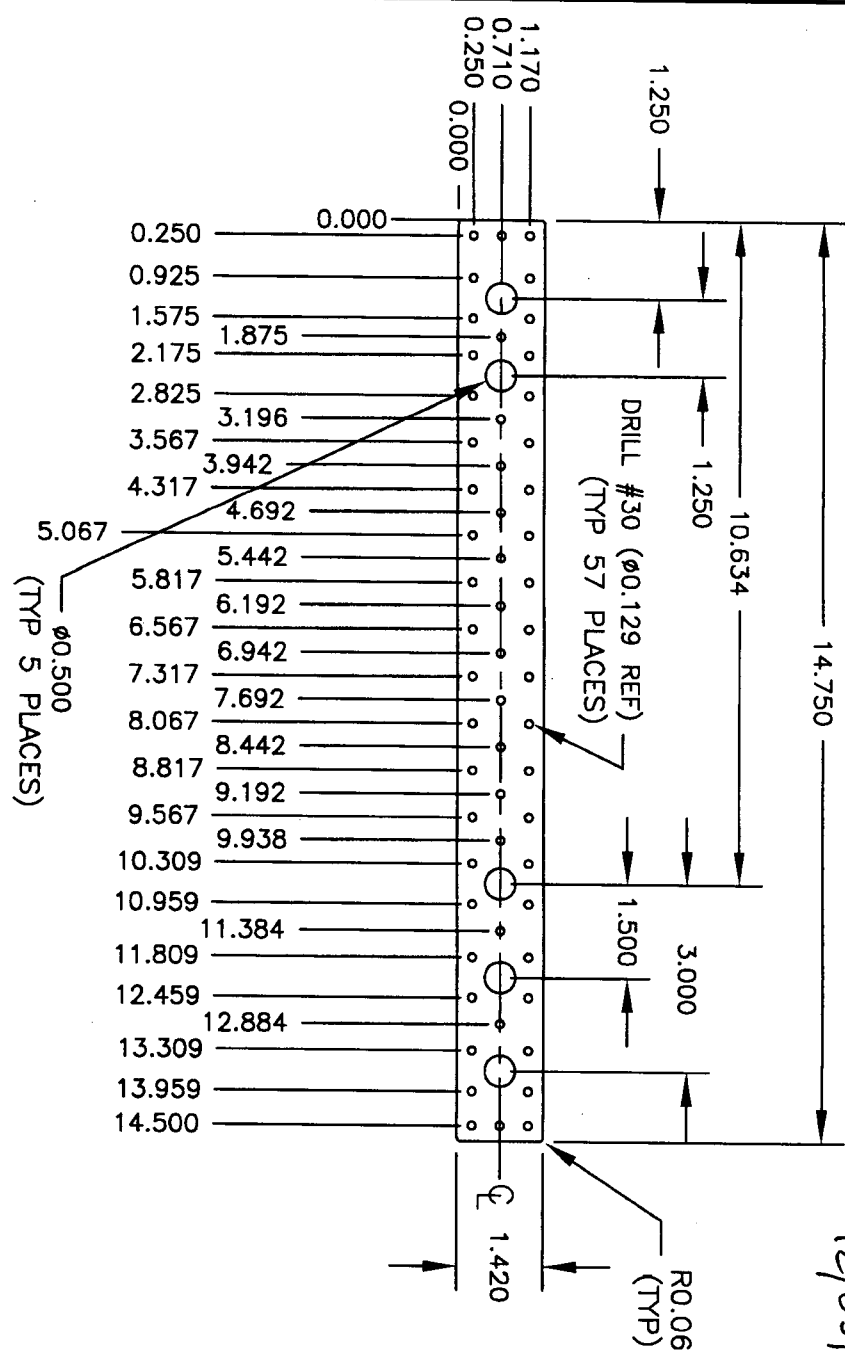
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

- D3283-1 DOUBLER**
- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82125 MLC  
12/03/23  
RELEASED  
07-08-23 PM  
PER FCN 959

DESIGN BY	APPROVED	DATE	07.06.01	TITLE	DOUBLER	SCALE	1:3
DART AEROSPACE USA, INC.	DRAWING NO. D3283	REV. E	SHEET 1 OF 2	NEW ISSUE	10.882 WAS 11.502	CHANGE HOLE PATTERN FOR -1	REDESIGN
					04.08.09	05.03.16	05.08.09
					07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

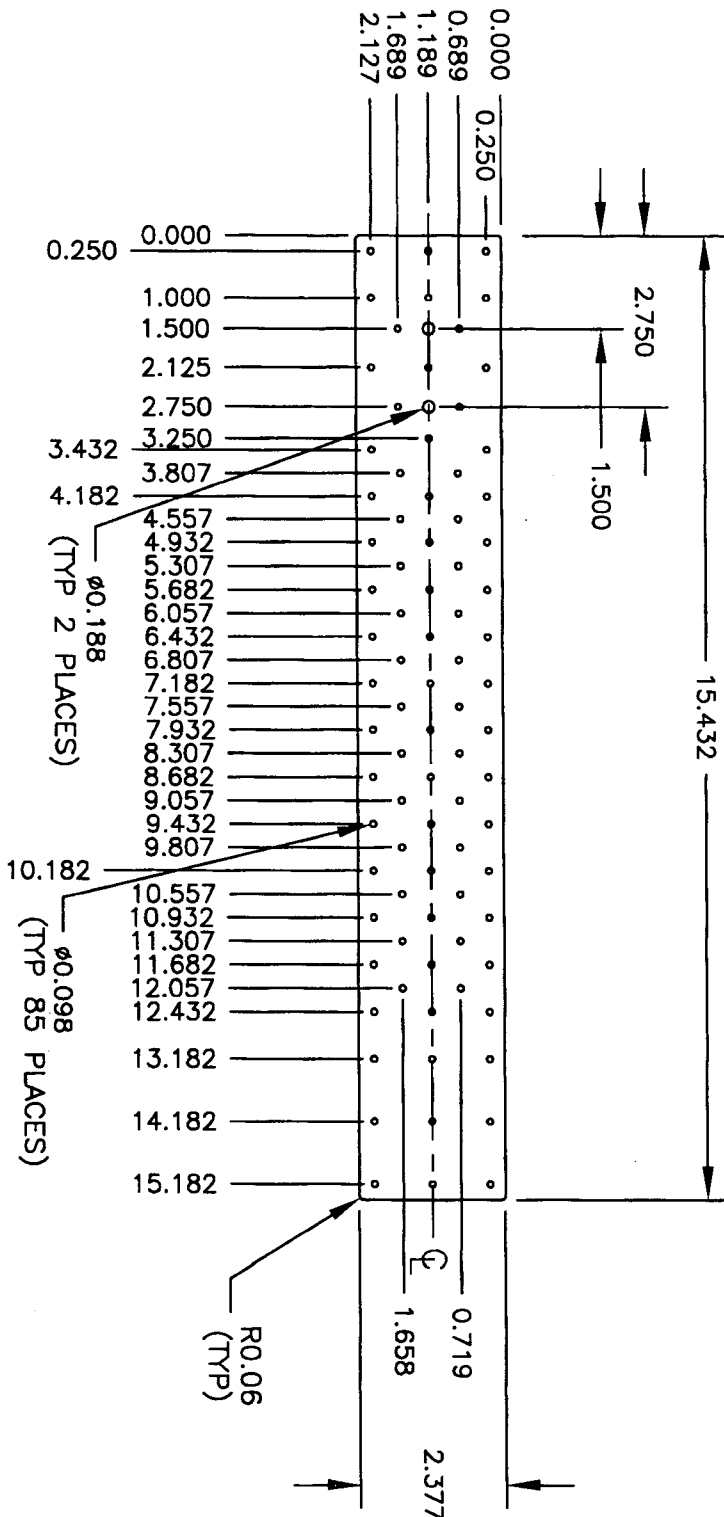
**NOTE:** Date & initial all entries

RELEASED  
07 08 49 PM  
PER ECN 959

**DART**

82125

DESIGN	CHECKED	APPROVED	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DATE	07.06.01	07.06.01	DOUBLE	SCALE
DRAWING NO.	D3283	SHEET 2 OF 2	REV. E	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

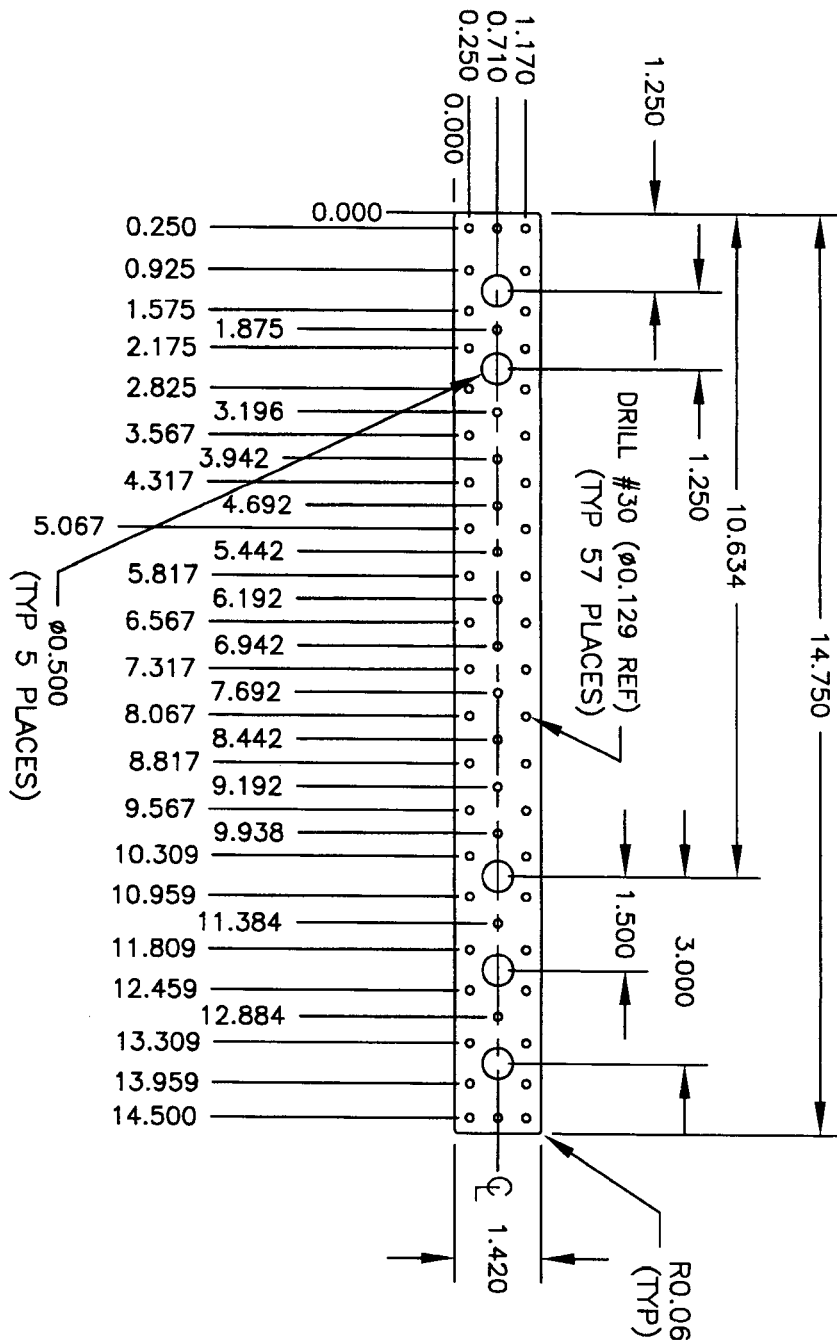
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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- D3283-1 DOUBLER**
- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

RELEASED  
07.08.09  
PER ECN 969

**DART**

82125

DATE	07.06.01	TITLE	DOUBLER	SCALE	1:3
DESIGN	APPROVED	DRAWING NO.	D3283	REV. E	SHEET 1 OF 2
DRAWN BY	APPROVED	DART Aerospace USA, INC.	PORT HADLOCK, WA		
A	04.05.06	NEW ISSUE	10.882 WAS 11.502	C	05.03.16
B	04.08.09	CHANGE HOLE PATTERN FOR -1	REDESIGN	D	05.08.09
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

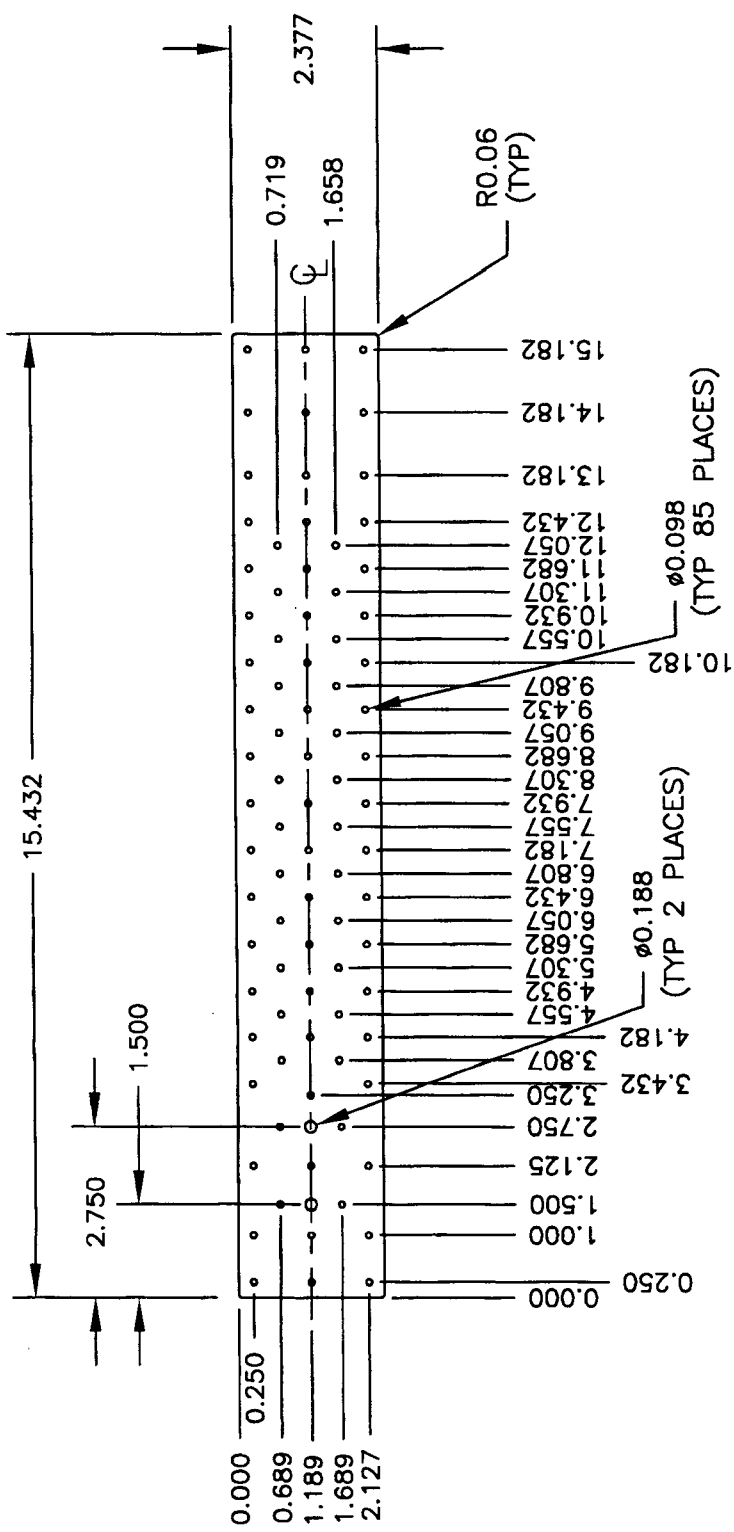


02125



DESIGN <i>9P</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. E SHEET 2 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3

**RELEASED**  
07.08.2004  
PER ECN 969



- D3283-3 DOUBLER**
- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries